

Date: Monday, 14/11/2005 8:21:56 AM
 User: Alba Panzuto

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BUSHING
 Job Number : 24401
 Estimate Number : 10310
 P.O. Number :
 This Issue : 14/11/2005 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : N/A
 Part Number : D26175
 Drawing Number : D2617 REV D2
 Project Number : N/A
 Drawing Revision : D2
 Material : N/A
 Due Date : 15/12/2005 Qty: 50 Um: Each
 Written By : See comment below
 Checked & Approved By : See comment below
 Comment : Est H 04.07.14 Reformat; added step 5 KJ/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
	Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA438 and Dwg D2617 Ø0.500" tubing x 0.058" wall <i>M18740</i> <i>ml 05/11/22</i> <i>50</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>gml</i> <i>05/11/22</i> <i>50</i>	
4.0	QC8	SECOND CHECK <i>J.L</i> <i>05/11/23</i> <i>50</i>
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: Deburr break all unmarked sharp edges 0.005 to 0.010 <i>DL 05/11/23</i> <i>50</i>	
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT ALODINE <i>SAD 05/11/27</i> <i>50</i>	
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>J 05-11-20</i> <i>50</i>	

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Drawing Name: BUSHING

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Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 05.11.28 50

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 49

CD 05/11/28 50

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

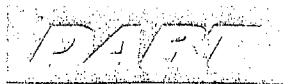
Suc 05/11/29 (50)

PS 05/11/29 50

Job Completion

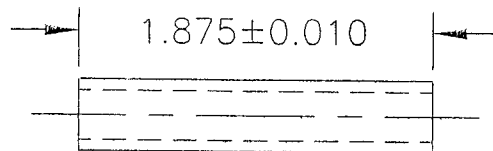


CONTROLLED COPY

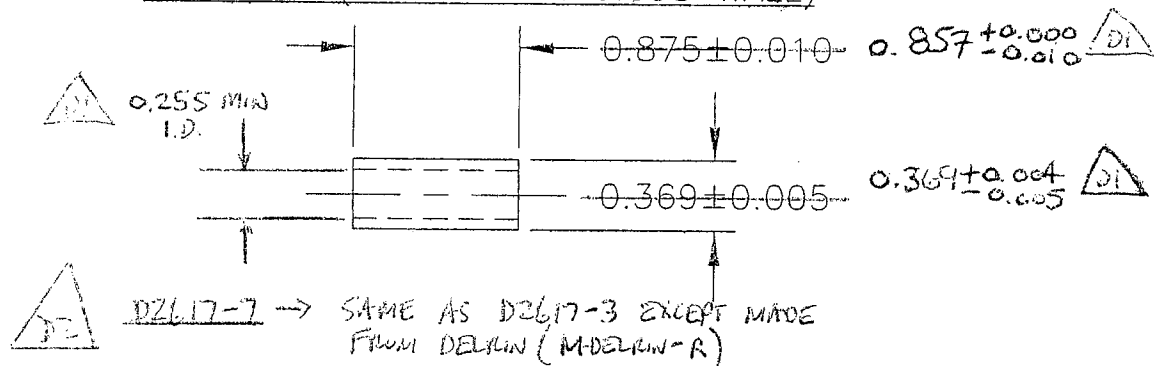


DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04	TITLE BUSHING SCALE 1:1		
A	96.10.08	NEW ISSUE	
B	97.05.08	.875 WAS 1.125	
C	97.06.04	0.369 DIA WAS 0.375	
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE	
DI	CP	04.07.12	CORRECT TOLERANCE (ACR 779)

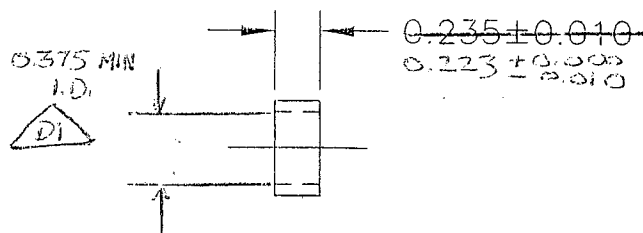
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:06 pm

Work Order No : 0024401
Project Name : D2617-5
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D2617-5
Description : Spacer
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 10-03-05
Est Finish Date : 10-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00.	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	2.50	100.00		
Production Cost :	0.00	33.45	100.00	0.00	33.45
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	2.50	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	33.45	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	33.45			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-33.45)

MIS d/B
u
11.13

